

Amendments to the Specification:

Please amend the specification as follows:

On page 21, please replace the paragraph that starts on line 6 with the word "During" and ends on line 19 with the word "reference" with the following amended paragraph:

During the present machining process, the cutting tool removes a relatively large amount of material because the angle between the steeply inclined side wall and the subsequent machined face is often in excess of 10 degrees, typically ranging from about 10 to about 45 degrees. Some of the groove side surfaces can then be formed in such a modified machined substrate by leaving more material on the cavities or protrusions during either or both machining steps, thereby reducing tool forces which could detrimentally cause distortions. Another benefit is less wear on the cutting tool. A modified machined substrate can also be used as a master from which future generations of positive/negative molds can be made. Various geometric configurations for modified machined substrate are disclosed in commonly assigned U.S. Patent Application Serial No. _____ (~~Attorney Docket No. 54222USA1A~~) 09/515,120 (U.S. Patent No. 6,540,367) filed on the same date herewith, entitled Structured Surface Articles Containing Geometric Structures with Compound Faces and Methods for Making Same, which is incorporated by reference.